

**INK RECORDING ELEMENT HAVING ADHESION PROMOTING
MATERIAL**

CROSS REFERENCE TO RELATED APPLICATIONS

5 Reference is made to commonly assigned, co-pending U.S. Patent Applications:
Serial Number 10/106867 by Charles E. Romano, Jr. et al. (Docket 83161) filed of even date herewith entitled "Ink Recording Element";
Serial Number 10/106882 by Charles E. Romano, Jr. et al. (Docket 83885)
10 filed of even date herewith entitled "Ink Recording Element Containing A Laminate Adhesion Promoting Inner Layer"; and
Serial Number 10/106882 by Charles E. Romano, Jr. (Docket 83245) filed of even date herewith entitled "Ink Recording Element", the disclosures of which are incorporated herein.

15 **FIELD OF THE INVENTION**

The present invention relates to an ink image-recording element.

BACKGROUND OF THE INVENTION

In a typical inkjet recording or printing system, ink droplets are ejected from a nozzle at high speeds towards a recording element or medium to
20 produce an image on the medium.

The recording elements typically comprise a support or a support material having on at least one surface thereof an ink-receiving or image-forming layer.

In order to achieve and maintain high quality images on such an
25 image-recording element, the recording element must:

Exhibit no banding, bleed, coalescence, or cracking in inked areas,
Exhibit the ability to absorb large amounts of ink and dry quickly
to avoid blocking,

Exhibit high optical densities in the printed areas, and
30 Exhibit freedom from differential gloss.

Have high levels of image fastness to avoid fade from contact with water or radiation by daylight, tungsten light, or fluorescent light.

In addition, an ink recording element should have excellent adhesive strength so that delamination does not occur.

While a wide variety of different types of image recording elements for use with ink printing are known, there are many unsolved problems
5 in the art and many deficiencies in the known products, which have severely limited their commercial usefulness. A major challenge in the design of an image-recording element is laminate adhesion. A typical coating from the prior art comprises a layer containing hydroxypropylmethyl cellulose, hydroxyethyl cellulose and a vinyl latex polymer, a layer of pectin, a layer of poly(vinyl
10 alcohol) and polyurethane, and a layer of lime processed osseine gelatin in the order recited. This formulation has demonstrated poor laminate adhesion. US Patent No. 6,015,624 discloses an inkjet recording element which has a base layer comprised of a blend of polyethylene-acrylic acid and at least one hydrophilic liquid absorbent polymer and an ink transmissive upper layer of methyl cellulose,
15 hydroxypropylmethyl cellulose and blends thereof and an organic acid salt. US Patent No. 5,567,507 discloses an inkjet recording element which has a base layer comprised of a blend of polyethylene-acrylic acid copolymer and polyvinylpyrrolidinone and an upper layer which comprises methyl cellulose, hydroxypropylmethyl cellulose. EP 1 110 745 discloses an inkjet recording
20 element which has a hydrophilic absorbing layer comprising gelatin or poly(vinyl alcohol), a laminate adhesion promoting layer comprising pectin or alginate and a hydrophilic overcoat layer comprising hydroxyethyl cellulose and blends thereof and an organic acid salt. These inkjet recording elements, as disclosed, demonstrate inadequate laminate adhesion. US 6,089,704 discloses an inkjet
25 recording element comprising a hydrophilic image-recording layer and an overcoat layer of a vinyl latex polymer. Coatings utilizing vinyl latex polymers frequently suffer from poor image quality. DE 197 21 238 A1 discloses the use of a single layer of succinylated pigskin gelatin in inkjet papers

It is an object of this invention to provide an ink recording element
30 which has excellent image quality, less differential gloss, and better laminate adhesion than the elements of the prior art.

SUMMARY OF THE INVENTION

These and other objects are achieved in accordance with the invention which comprises an ink recording element comprising at least one solvent absorbing layer comprising an amine inactivated gelatin.

5 In a preferred embodiment, a specific combination of image receiving layers, each comprised of specific materials and arranged in a specific sequence on a support material, yields excellent ink imaging performance for a wide range of commercially available printing systems, especially with respect to image quality, differential gloss, and laminate adhesion.

10 DETAILED DESCRIPTION OF THE INVENTION

The present invention relates to an ink recording element comprising a support having thereon a hydrophilic absorbing layer comprising an amine inactivated absorbing gelatin. In a preferred embodiment, the element includes a hydrophilic overcoat layer comprising cellulose ether and a vinyl latex
15 polymer. The recording element may further comprise at least one hydrophilic inner layer comprising poly(vinyl alcohol) located between the hydrophilic absorbing layer and the hydrophilic overcoat layer. Another embodiment of the invention relates to an ink printing method comprising providing an ink recording element as described above, and applying liquid ink droplets thereon in an image-
20 wise manner.

The present invention provides for improvements in laminate adhesion over the prior art. Laminate adhesion is the adhesion of the recording element to the laminate. Compositional changes in any of the various layers may affect laminate adhesion. Lamination as used herein is the process of applying a
25 thin plastic film having an adhesive layer on one side on top of the ink receiving layers, usually with the aid of heat and/or pressure. The film can be glossy, semi-glossy or matte and may contain additives modifying its optical properties. The film usually has a thickness of between 25-250 microns (1-10 mils).

The amine inactivated absorbing gelatin may comprise gelatin
30 where the amino group is inactivated (such as acetylated gelatin, phthaloylated gelatin, malenoylated gelatin, benzoylated gelatin, succinylated gelatin, methyl urea gelatin, phenylcarbamoylated gelatin, and carboxy modified gelatin) and the

gelatin has a bloom strength of between 100 grams and 350 grams. The amine inactivated absorbing gelatin may also be used in a blend with unmodified gelatin. For example, succinylated pigskin gelatin may be blended with non-succinylated pigskin gelatin. In such a blend, the succinylated pigskin gelatin is present in an amount between 5% and 95% by weight.

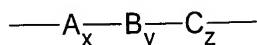
This absorbing gelatin layer may also contain other hydrophilic materials such as naturally-occurring hydrophilic colloids and gums such as albumin, guar, xanthan, acacia, chitosan, starches and their derivatives, functionalized proteins, functionalized gums and starches, and cellulose ethers and their derivatives, polyvinylloxazoline, such as poly(2-ethyl-2-oxazoline) (PEOX), non-modified gelatins, polyvinylmethyloxazoline, polyoxides, polyethers, poly(ethylene imine), poly(acrylic acid), poly(methacrylic acid), n-vinyl amides including polyacrylamide and polyvinylpyrrolidinone (PVP), and poly(vinyl alcohol) derivatives and copolymers, such as copolymers of poly(ethylene oxide) and poly(vinyl alcohol) (PEO-PVA).

The absorbing layer must effectively absorb both the water and the humectants commonly found in printing inks. In a preferred embodiment of the invention, the absorbing layer comprises succinylated gelatin or an alkyl-succinate modified gelatin where the alkyl group contains up to 22 carbons or preferably, 6 – 18 carbons. Also preferred is an alkylsuccinate pigskin gelatin modified with dodecenylsuccinic acid. The amine inactivated absorbing material employed in the ink image-recording layer may be present in any amount which is effective for the intended purpose. In general, the preferred dry layer thickness of gelatin is from about 5 microns to 60 microns, below which the layer is too thin to be effective and above which no additional gain in performance is noted with increased thickness.

The hydrophilic overcoat may comprise cellulose ether or cationically modified cellulose ether, such as methyl cellulose (MC), ethyl cellulose, hydroxypropyl cellulose (HPC), sodium carboxymethyl cellulose (CMC), calcium carboxymethyl cellulose, methylethyl cellulose, methylhydroxyethyl cellulose, hydroxypropylmethyl cellulose (HPMC), hydroxybutylmethyl cellulose, ethylhydroxyethyl cellulose, sodium

carboxymethyl-hydroxyethyl cellulose, and carboxymethylethyl cellulose, and cellulose ether esters such as hydroxypropylmethyl cellulose phthalate, hydroxypropylmethyl cellulose acetate succinate, hydroxypropyl cellulose acetate, esters of hydroxyethyl cellulose and diallyldimethyl ammonium chloride, esters of hydroxyethyl cellulose and 2-hydroxypropyltrimethylammonium chloride and esters of hydroxyethyl cellulose and a lauryldimethylammonium substituted epoxide (HEC-LDME), such as Quatrisoft® LM200 (Amerchol Corp.), as well as hydroxyethyl cellulose grafted with alkyl C₁₂-C₁₄ chains. The overcoat may also contain a vinyl latex polymer where the polymer has the following formula:

10



wherein:

A is a hydrophilic or reactive, vinyl monomer such as hydroxyethyl acrylate, hydroxyethyl methacrylate, acrylic acid, methacrylic acid, acrylic acid, itaconic acid, vinyl alcohol, acrylamide, methacrylamide, hydroxyethylacrylamide, 2-(methacryloyloxy)ethyl acetoacetate, or N-isobutoxymethacrylamide,

B is a hydrophobic, vinyl monomer such as methyl acrylate, methyl methacrylate, butyl acrylate, butyl methacrylate, ethyl acrylate, ethyl methacrylate, isopropyl acrylate, cyclohexyl acrylate, norbornyl acrylate, vinyl acetate, vinyl neodeconate or styrene,

C is a vinyl monomer bearing ionic charge such as [2-(acryloyloxy)ethyl]trimethylammonium chloride, [2-(acryloyloxy)ethyl]trimethylammonium methylsulfate, [2-(methacryloyloxy)ethyl]trimethylammonium chloride, [2-(methacryloyloxy)ethyl]trimethylammonium methylsulfate, 2-aminoethyl methacrylate hydrochloride, 3-aminopropylmethacrylamide hydrochloride, 1-methyl-4-vinylpyridinium chloride, 1-methyl-3-vinylimidazolium iodide, 2-acrylamido-2-methyl-1-propanesulfonic acid sodium salt, 3-methacryloyloxy-1-propanesulfonic acid, sodium salt, or

poly(n-butyl acrylate-co-2-(methacryloyloxy)-ethyl acetoacetate-co-2-acrylamide-2-methyl-1-propanesulfonic acid sodium salt),

x is from about 10 to about 80 mole %,

y is from about 0 to about 85 mole %, and

5 z is from about 2 to about 20 mole %.

In a preferred embodiment of the invention, the hydrophilic overcoat layer comprises a mixture of hydroxyethyl cellulose, hydroxypropylmethyl cellulose, and poly(n-butyl acrylate-co-2-aminoethyl methacrylate-co-2-hydroxyethyl methacrylate). Preferred is a weight ratio of
10 about 37.5:37.5:25. This weight ratio produces optimal laminate properties. The preferred dry thickness of the overcoat layer is from about 0.5 to 5 microns as is common in practice.

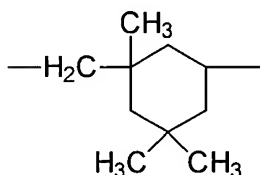
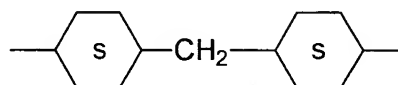
The hydrophilic inner layer or layers comprise other hydrophilic materials such as naturally-occurring hydrophilic colloids and gums such as
15 albumin, guar, xanthan, acacia, chitosan, starches and their derivatives, functionalized proteins, functionalized gums and starches, and cellulose ethers and their derivatives, polyvinylloxazoline, such as poly(2-ethyl-2-oxazoline) (PEOX), non-modified osseine or bone or pigskin gelatins, polyvinylmethyloxazoline, polyoxides, polyethers, poly(ethylene imine), n-vinyl
20 amides including polyacrylamide and polyvinylpyrrolidinone (PVP), and poly(vinyl alcohol) derivatives and copolymers, such as copolymers of poly(ethylene oxide) and poly(vinyl alcohol) (PEO-PVA), polyurethanes and latices, such as polyesters and polyacrylates. In a preferred embodiment of the invention, the hydrophilic absorbing layers comprise a base layer comprising
25 gelatin and an upper layer comprising a mixture of poly(vinyl alcohol) and Witcobond ® 232 polyurethane dispersion in a ratio of about 50:50 to about 95:5 PVA to polyurethane. Outside of this weight ratio, incompatibility or poorer adhesion may occur.

The hydrophilic materials employed in the image-recording layer
30 may be present in any amount which is effective for the intended purpose. In general, the dry layer thickness of the poly(vinyl alcohol)/Witcobond ® 232 layer is from about 0.5 to 5 microns.

36

[illegible]

10

c1ccc(cc1)Cc2ccc(cc2)

15

20

copolymer of styrene oxide, propylene oxide, tetrahydrofuran, butylene oxide or epichlorohydrin;

R₂ represents the residue of a diol having a molecular weight less than about 500, such as the diols listed above for A; and

5 R₃ represents an alkylene, arylene or aralkylene linking group containing one or more phosphonate, carboxylate or sulfonate groups which have been neutralized with a base, such as triethylamine, sodium hydroxide, potassium hydroxide, etc; and

R₄ is optional and may represent the residue of a diamine
10 having a molecular weight less than about 500, such as ethylene diamine, diethylene triamine, propylene diamine, butylene diamine, hexamethylene diamine, cyclohexylene diamine, phenylene diamine, tolylene diamine, xylylene diamine, 3,3'-dinitrobenzidine, 4,4'-methylenebis(2-chloroaniline), 3,3'-dichloro-4,4'-biphenyl diamine, 2,6-diaminopyridine, 4,4'-diamino
15 diphenylmethane, and adducts of diethylene triamine with acrylate or its hydrolyzed products.

These materials are preferred due to their availability and compatibility with the present invention.

The polyurethane employed in the invention preferably has a
20 T_g between about -50°C and 100°C. A plasticizer may also be added if desired. In a preferred embodiment of the invention, the polyurethane has a number average molecular weight of from about 5,000 to about 100,000, more preferably from 10,000 to 50,000. The anionic, water-dispersible polyurethane employed in the invention may be prepared as described in
25 "Polyurethane Handbook", Hanser Publishers, Munich Vienna, 1985. An example of an anionic, water-dispersible polyurethane that may be used in the invention is Witcobond ® 232 (Witco Corporation). Polyurethanes with these properties are readily available and effective in the present invention.

Matte particles may be added to any or all of the layers described
30 in order to provide enhanced printer transport, resistance to ink offset, or to change the appearance of the ink receiving layer to satin or matte finish. In

addition, surfactants, defoamers, or other coatability-enhancing materials may be added as required by the coating technique chosen.

Typically, dye mordants are added to ink receiving layers in order to improve water and humidity resistance. However, most mordant materials adversely affect dye light stability. Any polymeric mordant can be used in the image-recording layer of the invention provided it does not adversely affect light fade resistance. For example, there may be used a cationic polymer, e.g., a polymeric quaternary ammonium compound, or a basic polymer, such as poly(N,N-dimethylaminoethyl methacrylate), polyalkylenepolyamines, and products of the condensation thereof with dicyanodiamide, amine-epichlorohydrin polycondensates, lecithin and phospholipid compounds. Examples of mordants useful in the invention include poly(vinylbenzyltrimethylammonium chloride-co-ethylene glycol dimethacrylate), poly(vinylbenzyltrimethylammonium chloride-co-divinylbenzene), poly(diallyldimethylammonium chloride), poly([2-(methacryloyloxy)ethyl]trimethylammonium methylsulfate), poly([3-(methacryloyloxy)propyl]trimethylammonium chloride), a copolymer of vinylpyrrolidinone and 1-vinyl-3-methylimidazolium chloride, and hydroxyethyl cellulose derivitized with 1-chloro-3-(N,N,N-trimethylammonium)propane.

Any support or substrate may be used in the recording element of the invention. The support for the ink recording element used in the invention can be any of those usually used for inkjet receivers, such as resin-coated paper, paper, polyesters, or microporous materials such as polyethylene polymer-containing material sold by PPG Industries, Inc., Pittsburgh, Pennsylvania under the trade name of Teslin®, Tyvek® synthetic paper (DuPont Corp.), impregnated paper such as Duraform®, and OPPalyte® films (Mobil Chemical Co.) and other composite films listed in U.S. Patent 5,244,861. Opaque supports include plain or calendered paper, coated paper, paper coated with protective polyolefin layers, synthetic paper, photographic paper support, melt-extrusion-coated paper, and laminated paper, such as biaxially oriented support laminates. Biaxially oriented support laminates are described in U.S. Patents 5,853,965, 5,866,282, 5,874,205, 5,888,643, 5,888,681, 5,888,683, and 5,888,714, the disclosures of which are hereby incorporated by reference. These biaxially oriented supports include a

paper base and a biaxially oriented polyolefin sheet, typically polypropylene, laminated to one or both sides of the paper base. Transparent supports include glass, cellulose derivatives, e.g., a cellulose ester, cellulose triacetate, cellulose diacetate, cellulose acetate propionate, cellulose acetate butyrate, polyesters, such as poly(ethylene terephthalate), poly(ethylene naphthalate), poly(1,4-cyclohexanedimethylene terephthalate), poly(butylene terephthalate), and copolymers thereof, polyimides, polyamides, polycarbonates, poly(vinyl chloride), polystyrene, polyolefins, such as polyethylene or polypropylene, polysulfones, polyacrylates, polyetherimides, and mixtures thereof. The papers listed above include a broad range of papers, from high end papers, such as photographic paper to low end papers, such as newsprint. In particular, polyethylene-coated paper or poly(ethylene terephthalate) are preferred and are commonly used in imaging applications.

The support is suitably of a thickness of from 50 to 500 μm , preferably from 75 to 300 μm to provide acceptable look and feel as well as effectiveness in the present invention. Antioxidants, antistatic agents, plasticizers, dyes, pigments and other known additives may be incorporated into the support, if desired.

In another embodiment of the invention, a filled layer containing light scattering particles such as titania may be situated between a clear support material and the ink receptive multilayer described herein. Such a combination may be effectively used as a backlit material for signage applications. Yet another embodiment which yields an ink receiver with appropriate properties for backlit display applications results from selection of a partially voided or filled poly(ethylene terephthalate) film as a support material, in which the voids or fillers in the support material supply sufficient light scattering to diffuse light sources situated behind the image.

In order to improve the adhesion of the image-recording layer to the support, the surface of the support may be subjected to a corona-discharge treatment prior to applying the image-recording layer. The adhesion of the image-receiving layer to the support may also be improved by coating a subbing layer on the support. Examples of materials useful in a subbing layer include halogenated

phenols and partially hydrolyzed vinyl chloride-co-vinyl acetate polymer. In order to impart mechanical durability to an ink recording element, crosslinkers which act upon the binder discussed above may be added in small quantities. Such an additive improves the cohesive strength of the layer. Crosslinkers such as

5 carbodiimides, polyfunctional aziridines, aldehydes, isocyanates, epoxides, polyvalent metal cations, and the like may all be used.

To improve colorant fade, UV absorbers, radical quenchers or antioxidants may also be added as is well known in the art. Other additives include pH modifiers, adhesion promoters, rheology modifiers, surfactants,

10 biocides, lubricants, dyes, optical brighteners, matte agents, antistatic agents, etc. In order to obtain adequate coatability, additives known to those familiar with such art such as surfactants, defoamers, alcohol and the like may be used. A common level for coating aids is 0.01 to 0.30 wt. % active coating aid based on the total solution weight. These coating aids can be nonionic, anionic, cationic or

15 amphoteric. Specific examples are described in MCCUTCHEON's Volume 1: Emulsifiers and Detergents, 1995, North American Edition.

Optionally, an additional backing layer or coating may be applied to the backside of a support (i.e., the side of the support opposite the side on which the image-recording layers are coated) for the purposes of improving the

20 machine-handling properties and curl of the recording element, controlling the friction and resistivity thereof, and the like.

Typically, the backing layer may comprise a binder and a filler. Typical fillers include amorphous and crystalline silicas, poly(methyl methacrylate), hollow sphere polystyrene beads, micro-crystalline cellulose, zinc

25 oxide, talc, and the like. The filler loaded in the backing layer is generally less than 5 percent by weight of the binder component and the average particle size of the filler material is in the range of 5 to 30 μm . Typical binders used in the backing layer are polymers such as polyacrylates, gelatin, polymethacrylates, polystyrenes, polyacrylamides, vinyl chloride-vinyl acetate copolymers,

30 poly(vinyl alcohol), cellulose derivatives, and the like. Additionally, an antistatic agent also can be included in the backing layer to prevent static hindrance of the recording element. Particularly suitable antistatic agents are compounds such as

dodecylbenzenesulfonate sodium salt, octylsulfonate potassium salt, oligostyrenesulfonate sodium salt, laurylsulfosuccinate sodium salt, and the like. The antistatic agent may be added to the binder composition in an amount of 0.1 to 15 percent by weight, based on the weight of the binder. An image-recording layer may also be coated on the backside, if desired.

While not necessary, the hydrophilic material layers described above may also include a crosslinker. Such an additive can improve the adhesion of the ink receptive layer to the substrate as well as contribute to the cohesive strength and water resistance of the layer. Crosslinkers such as carbodiimides, polyfunctional aziridines, melamine formaldehydes, isocyanates, epoxides, and the like may be used. If a crosslinker is added, care must be taken that excessive amounts are not used as this will decrease the swellability of the layer, reducing the drying rate of the printed areas.

Coating compositions employed in the invention may be applied by any number of well known techniques, including dip-coating, wound-wire rod coating, doctor blade coating, gravure and reverse-roll coating, slide coating, bead coating, extrusion coating, curtain coating and the like. Known coating and drying methods are described in further detail in Research Disclosure no. 308119, published Dec. 1989, pages 1007 to 1008. Slide coating is preferred, in which the base layers and overcoat may be simultaneously applied. Slide coating, in which the base layers and overcoat may be simultaneously applied, is preferred as cost effective as well as useful in the present invention. After coating, the layers are generally dried by simple evaporation, which may be accelerated by known techniques such as convection heating.

Inks used to image the recording elements of the present invention are well-known in the art. The ink compositions used in inkjet printing typically are liquid compositions comprising a solvent or carrier liquid, dyes or pigments, humectants, organic solvents, detergents, thickeners, preservatives, and the like. The solvent or carrier liquid can be solely water or can be water mixed with other water-miscible solvents such as polyhydric alcohols. Inks in which organic materials such as polyhydric alcohols are the predominant carrier or solvent liquid may also be used. Particularly useful are mixed solvents of water and polyhydric

alcohols. The dyes used in such compositions are typically water-soluble direct or acid type dyes. Such liquid compositions have been described extensively in the prior art including, for example, US-A-4,381,946, US-A-4,239,543 and US-A-4,781,758.

5 Although the recording elements disclosed herein have been referred to primarily as being useful for inkjet printers, they also can be used as recording media for pen plotter assemblies. Pen plotters operate by writing directly on the surface of a recording medium using a pen consisting of a bundle of capillary tubes in contact with an ink reservoir.

10 As used herein the phrase "recording element" is a material that may be used with an imaging support for the transfer of images to the element by techniques such as ink jet printing or thermal dye (ink) transfer. The thermal dye (ink) image-receiving layer of the receiving elements of the invention may comprise, for example, a polycarbonate, a polyurethane, a polyester, polyvinyl
15 chloride, poly(styrene-co-acrylonitrile), poly(caprolactone) or mixtures thereof. The ink-receiving layer may be present in any amount which is effective for the intended purpose.

 Ink-donor elements that are used with the ink-receiving element of the invention conventionally comprise a support having thereon an ink containing
20 layer. Any ink can be used in the ink-donor employed in the invention provided it is transferable to the ink-receiving layer by the action of heat. Especially good results have been obtained with sublimable inks. Ink donors applicable for use in the present invention are described, e.g., in U.S. Pat. Nos. 4,916,112; 4,927,803 and 5,023,228.

25 As noted above, ink-donor elements are used to form an ink transfer image. Such a process comprises image-wise-heating an ink-donor element and transferring an ink image to an ink-receiving element as described above to form the ink transfer image.

 In a preferred embodiment of the thermal ink transfer method of
30 printing, an ink donor element is employed which compromises a poly-(ethylene terephthalate) support coated with sequential repeating areas of cyan, magenta, and yellow dye, and the ink transfer steps are sequentially performed for each

color to obtain a three-color ink transfer image. Of course, when the process is only performed for a single color, then a monochrome ink transfer image is obtained.

A thermal ink transfer assemblage of the invention comprises (a)
5 an ink-donor element, and (b) an ink-receiving element as described above, the ink-receiving element being in a superposed relationship with the ink-donor element so that the ink layer of the donor element is in contact with the ink image-receiving layer of the receiving element.

When a three-color image is to be obtained, the above assemblage
10 is formed on three occasions during the time when heat is applied by the thermal printing head. After the first ink is transferred, the elements are peeled apart. A second ink-donor element (or another area of the donor element with a different ink area) is then brought in register with the ink-receiving element and the process repeated. The third color is obtained in the same manner.

15 The electrographic and electrophotographic processes and their individual steps have been well described in detail in many books and publications. The processes incorporate the basic steps of creating an electrostatic image, developing that image with charged, colored particles (toner), optionally transferring the resulting developed image to a secondary substrate, and fixing the
20 image to the substrate. There are numerous variations in these processes and basic steps; the use of liquid toners in place of dry toners is simply one of those variations.

The first basic step, creation of an electrostatic image, can be accomplished by a variety of methods. In one form of the electrophotographic
25 process of copiers uses imagewise photodischarge, through analog or digital exposure, of an uniformly charged photoconductor. The photoconductor may be a single-use system, or it may be rechargeable and reimageable, like those based on selenium or organic photoreceptors.

In an alternate electrographic process, electrostatic images are
30 created iono-graphically. The latent image is created on dielectric (charge-holding) medium, either paper or film. Voltage is applied to selected metal styli or writing nibs from an array of styli spaced across the width of the medium,

causing a dielectric breakdown of the air between the selected styli and the medium. Ions are created, which form the latent image on the medium.

Electrostatic images, however generated, are developed with oppositely charged toner particles. For development with liquid toners, the liquid
5 developer is brought into direct contact with the electrostatic image. Usually a flowing liquid is employed, to ensure that sufficient toner particles are available for development. The field created by the electrostatic image causes the charged particles, suspended in a nonconductive liquid, to move by electrophoresis. The charge of the latent electrostatic image is thus neutralized by the oppositely
10 charged particles. The theory and physics of electrophoretic development with liquid toners are well described in many books and publications.

If a reimageable photoreceptor or an electrographic master is used, the toned image is transferred to paper (or other substrate). The paper is charged electrostatically, with the polarity chosen to cause the toner particles to transfer to
15 the paper. Finally, the toned image is fixed to the paper. For self-fixing toners, residual liquid is removed from the paper by air-drying or heating. Upon evaporation of the solvent these toners form a film bonded to the paper. For heat-fusible toners, thermoplastic polymers are used as part of the particle. Heating both removes residual liquid and fixes the toner to paper.

20 The image-recording layer or layers used in the recording element of the present invention can also contain various known additives, including matting agents such as titanium dioxide, zinc oxide, silica and polymeric beads such as crosslinked poly(methyl methacrylate) or polystyrene beads for the purposes of contributing to the non-blocking characteristics of the recording
25 elements used in the present invention and to control the smudge resistance thereof, surfactants such as non-ionic, hydrocarbon or fluorocarbon surfactants or cationic surfactants, such as quaternary ammonium salts for the purpose of improving the aging behavior of the ink-absorbent resin or layer, promoting the absorption and drying of a subsequently applied ink thereto, enhancing the surface
30 uniformity of the ink-receiving layer and adjusting the surface tension of the dried coating, fluorescent dyes, pH controllers, antifoaming agents, lubricants, preservatives, viscosity modifiers, dye-fixing agents, water proofing agents,

dispersing agents, UV-absorbing agents, mildew-proofing agents, organic or inorganic mordants, antistatic agents, anti-oxidants, optical brighteners, and the like. Such additives can be selected from known compounds or materials in accordance with the objects to be achieved.

5 The following examples are provided to illustrate the invention.

Example 1

A polyethylene resin coated paper was treated by corona discharge and coated by means of an extrusion/slide hopper with a mixture of 10% gelatin solution in water, (succinylated pigskin gelatin containing a C12 group, Kind & Knox Gelatine Co.), and 0.6% 12 micron polystyrene beads, dry thickness of
10 about 7.0 microns. An inner layer consisted of a 5% mixture of Elvanol ® 52-22 poly(vinyl alcohol) (DuPont) and a 30% dispersion of Witcobond ® 232 polyurethane (Witco Corp), (77:23 ratio by weight) at a dry thickness of 1.5 microns. An overcoat layer consisting of hydroxyethyl cellulose (HEC QP 300,
15 Dow), hydroxypropylmethyl cellulose (Methocel ® K100LV, Dow), and poly(n-butyl acrylate-co-2-aminoethyl methacrylate-co-2-hydroxyethyl methacrylate) (Eastman Kodak) and surfactants APG 325N (Cognis) and Surfactant 10G (Arch Chemical) in a weight ratio of 36.3/36.3/24.2/2.4/0.7 were coated over the gelatin and poly(vinyl alcohol)/polyurethane layers at a dry thickness of 1 micron. The
20 coatings were dried thoroughly by forced air heat after application of the coating solutions.

Example 2

As in Example 1, but used a succinylated pigskin gelatin (Kind & Knox Gelatine Co) which does not contain a group having 12 carbons.

25 Example 3

As in Example 2, but used a 90%/10% by weight mixture of succinylated pigskin gelatin (Kind & Knox Gelatine Co) and non-modified pigskin gelatin (Eastman Gelatine).

Example 4

30 As Example 2 but used a 10%/90% by weight mixture of succinylated pigskin gelatin (Kind & Knox Gelatine Co) and non-modified pigskin gelatin (Kind & Knox Gelatine Co.).

Control 1

A Kodak commercial paper product containing lime processed osseine gelatin.

Control 2

5 As in Example 1, but used acid processed osseine gelatin (Croda Co)

Control 3

As in Example 1, but used a non-modified pigskin gelatin (Kind & Knox Gelatine Co)

10 Control 4

As in Example 1, but used lime processed osseine gelatin (Eastman Gelatine Co)

Laminate Adhesion Test

15 A 2x4 in. composite black patch using cyan, magenta, yellow, and black ink was printed at 320% laydown at ambient room conditions with an Encad ® 700 printer using E.I Premium Plus Inks Catalog No. 854-4553 (black), 863-0501 (cyan), 870-8414 (magenta), and 144-6681 (yellow) (Eastman Kodak Company). Specific printer settings are listed below in Table 1:

Table 1

dpi	Pattern	Quality	Passes	Speed	Bidir
600		Best (photo)	6	10 (Fast)	Yes

20

About 2 hrs. after printing, 1/2" wide, orange, Mylar ® tape was placed down the side of the print target, partly covering the 320% black patch to provide an area to initiate the peel test. The samples were then laminated with Print Guard UV Lustre® laminate, Catalog No. 1315-3 (Hunt Corporation) using
25 a Seal 400 Hot Roll Laminator with rolls set at 200°F, 0" nip between the rollers, at a speed of 4 ft per minute. The samples were sandwiched between 2 laminates, the test laminate on the face of the print and ThermaShield ® Gloss, 3 mil Catalog No. 3226 (Hunt Corporation) on the back.

Using a sharp paper cutter, 1x2 ½ in. test strips were cut across the orange tape and the composite black patch. The laminate was peeled up from the orange tape and a 1x 2½ in. leader was attached to the edge of the laminate. The leader was clamped in the upper jaw of an Instron ® Model No.1122 and the
5 taped portion of the sample was clamped in the lower jaw. The laminate was then peeled a distance of about ½ in. to 1 in. along the sample at a 180° angle with a crosshead constant rate of extension of 4" per minute and a calibrated load cell with a capacity of 2 kg. A plot of peel force versus time was made and by
10 averaging the pull force over the plateau region of the peel, an average peel force was calculated in Newtons/meter. The results of the peel force test are reported below in Table 2.

Table 2

Example	Peel Force
Example 1	266
Example 2	237
Example 3	202
Example 4	160
Control 1	121
Control 2	200
Control 3	100
Control 4	141

The above results show that the invention examples have better
15 laminate adhesion than the control elements.

The invention has been described in detail with particular reference to certain preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention.